



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1701
Job Sheet 214434



Part No: 647.1701

Job Qty: 6 pcs

DAS
21
9-89

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/20

Job Tracking No:

Due Date: 11/16/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 647.1700 REV.F IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS IPP REV:B 18.03.01 REVISE BOM AS PER DWG DD VERF:DP IPP REV:C 20.07.07 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		11/14/20	0.00	0.00	Packaging 1 - SCH-S		DAS 58 NOV 09 2020 9-89
120	Small Fab - 2 - B4B	4 pcs		11/16/20	0.00	1.64	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		DAS 58 NOV 09 2020 9-89
							Small Fab - 9 - B4B		
							Small Fab - Various 1 - B4B		
130	QC 5	4 pcs		11/16/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		



Container No: S311606



Part: 647.1701

Job No: 214434

Serial No/Batch: S311606

Revision: REV.F

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/09/20

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				QC 5 - 81	
				QC 5 - 82	NOV 10 2020
210 Packaging 3-1 - Stock - B4B	4 pcs	11/16/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	NOV 10 2020
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
220 QC 21 - SA	4 pcs	11/16/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	
				QC 21 - SA - 28	NOV 10 2020

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine 6- Re-assemble as per dwg *** TOUCH UP RIVET WITH PRIMER *** PRIMER BATCH: _____ ***

130 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

220 - (QC21- Final Inspection - Work Order Release)

018022

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1712 ⁹⁵⁰ ₀₄₄	Gusset ⁰³¹ ₀₄₄	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	520466
647.1713 ⁰⁴⁴	Spacer ⁰⁴⁴	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	528908
CR3213-4-4 ⁰⁰¹⁰³¹	Rivet, Cherry	88 Ea (22 ea)	110-Packaging 1 - Pick Kit	5302185
MS21042-3 ³¹⁹	Nut use MS21042L3 per QSI 017	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	5309678
MS27039-1-14 ⁰⁰⁰	Screw	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	5105000
NAS1149F0332P	Washer (AN960-10L)	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	5304837
647.1710 ⁹⁵⁰	Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5098322X5 528017
647.1711 ⁰⁴⁴	Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	520509X 1

528439

5308760

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	647.1710	4	9	0
	647.1711	4	1	0
	647.1712	4	17	0
	647.1713	4	18	0
	CR3213-4-4	88	27	0
	MS21042-3	4	439	0
	MS27039-1-14	4	302	0
	NAS1149F0332P	8	1,719	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					